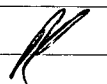




Work Order ID 63330


Wednesday, October 27, 2010 3:50:35 PM

Page 1

Item ID:	D4154-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate Assembly				Stop	
Start Date:	10/27/2010	Start Qty:	4.00			
Required Date:	11/11/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-28	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4154	A								

100		0.00
		
Large Fab		
Large Fab		

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
2059 B Hardcoat Welding Rod
BATCH#: M115879.

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
304 S.S. Welding Rod
BATCH #: M101744.

3-Transfer drill holes in bar

4- (AT9684) use to check for fit.

EL 10-11-4 (X4)

110		0.00
		
QC		
Quality Control		

QC9- Inspect visual per QSI004- Fusion Welds

Memo

PL 10-10-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63330

Wednesday, October 27, 2010 3:50:35 PM

Page 2

Item ID: D4154-041

Accept

Setup Start

Revision ID:

Item Name: Wearplate Assembly

Stop

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



8/10/10/05

74

test fits in slides F+
not great but will work

M 112588

H 10-11-5

10:15

320°

10:15

=> JH

10/11/05

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63330

Wednesday, October 27, 2010 3:50:35 PM

Page 3

Item ID:	D4154-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate Assembly				Stop	
Start Date:	10/27/2010	Start Qty:	4.00			
Required Date:	11/11/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Small Fab		0.00							
Small Fab	Memo 1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154. <i>USE ROCK GUARD-BELGE</i>	0.00							
160  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo <i>8 idulos</i>	0.00							
170  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							

10 11 05 (4)

(74)

10 11 05 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63330

Wednesday, October 27, 2010 3:50:35 PM

Page 4

Item ID: D4154-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate Assembly

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/08 [Signature]

PS-10-11-08 [Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:50:39 PM

Page 1

Work Order ID: 63330

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 10/27/2010


Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1  Plate		Manufactured	No			100	Each	1.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



EL 10-11-4.

B 63331 x4

Location

Loc Qty


Loc Code

WA

1

62199

1

D4155-1  Bar		Manufactured	No			100	Each	2.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



EL 10-11-4.

B 623 B4 x4

Location

Loc Qty

Loc Code

ST

2

60976

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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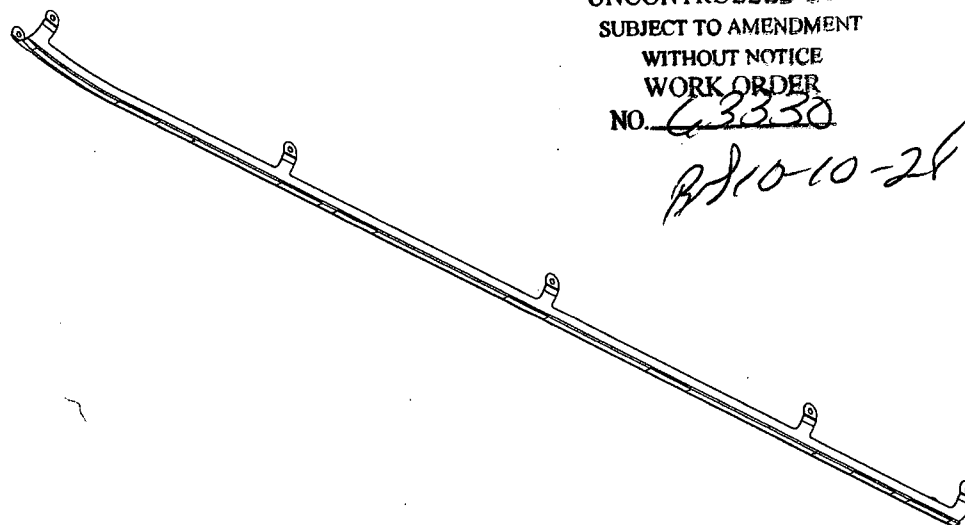
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. G-3330

BJ10-10-24



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

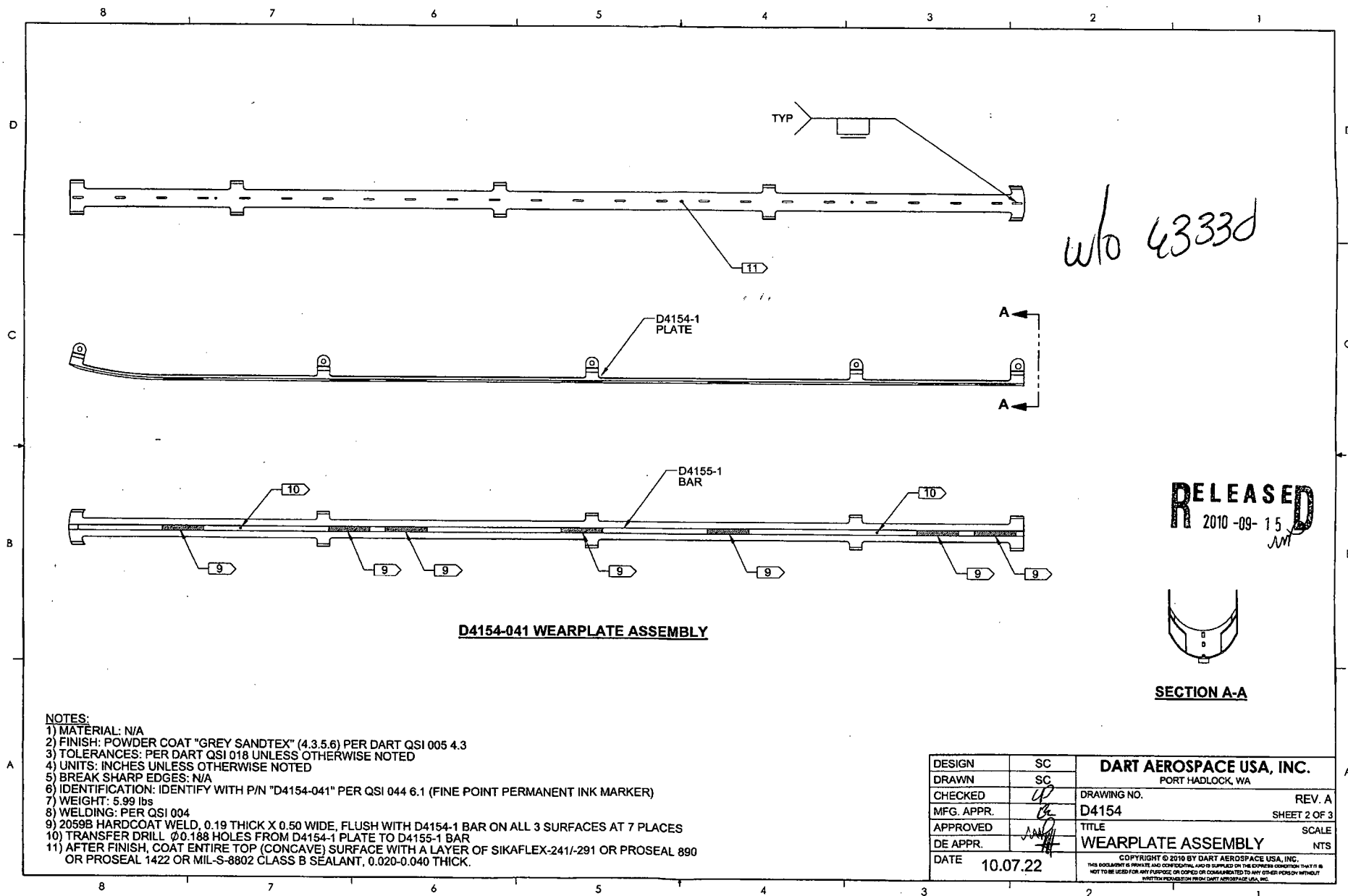
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